



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D500-572-011
Job Sheet 180954



Part No: D500-572-011

Job Qty: 1 ea

Part Name: MD369/MD500 Bearpaws



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG IIND500-572 REV A, DSI 9770 REV A IPP Rev:C 04.02.17 Blank size changed KJ/JLM IPP Rev:D 07-01-02 Was K10007 JLM IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Stores/Pkg-2		AUG 13 2018
160	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging1-5		AUG 13 2018
170	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC4		JRB
180	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3-2		JRB
185	DC	1 pcs	8/3/18	8/3/18	0.00	0.00	DC		18.08.13
190	QC21-FG	1 Ea	8/3/18	8/3/18	0.00	0.00	QC21		18.08.13

Part Op 180 - Identify and pack for shipping as per PPPD500-572-011

Descriptions: 185 - Photocopy bluefile and create labels per PPP D500-572-011 CHS005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-13A	Bolt	8 Ea (8 ea)	90-Start up Operation	5089382
D2274	Radius Block	8 Ea (8 ea)	90-Start up Operation	5089983
D2435	Bearpaw	2 Ea (2 ea)	90-Start up Operation	5062076
D2529	Washer	8 Ea (8 ea)	90-Start up Operation	5035678
D5472-1	Cushion	4 Ea (4 ea)	90-Start up Operation	516072
D5476-1	Clamp	4 Ea (4 ea)	90-Start up Operation	5050483
MS21042L4	Nut	8 Ea (8 ea)	90-Start up Operation	5087365
NAS1149D0463J	Washer	8 Ea (8 ea)	90-Start up Operation	5089279
QS200-M44S	Clamp	2 Ea (2 ea)	90-Start up Operation	5048406

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-13A	8	1,950	0
	D2274	8	235	0
	D2435	2	8	0
	D2529	8	1,585	0
	D5472-1	4	156	0
	D5476-1	4	28	0
	MS21042L4	8	3,594	0
	NAS1149D0463J	8	11,622	0
	QS200-M44S	2	10	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																						
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																				
Description Work Order Deviation		Container No: S101700 Part: D500-572-011 Job No: 180954 Serial No/Batch: S101700 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH90-17 Issue 7a FFA STC SH849NE 01/06/04, AUSTRIA		Completed By																																																																				
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OTHER : _____																																																																								

Part Specifications

Specifications could not be found.

Plex 7/18/18 10:49 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

REFERENCE ONLY**4. WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-572-011 Bearpaw Installation	8.5 lb 3.86 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	1105 in-lb 12.74 m-kg
D500-572-021 Narrow Bearpaw Installation	7.5 lb 3.41 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	975 in-lb 11.25 m-kg
D500-572-013 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	128 in 3.25 m	1459 in-lb 16.80 m-kg
D600-572-015 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	122 in 3.10 m	1391 in-lb 16.03 m-kg

5. PARTS LIST

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
X				D500-572-011	BEARPAW INSTALLATION
	X			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			X	D600-572-015	BEARPAW INSTALLATION
2				D2435	BEARPAW
	2			D2671	BEARPAW
		2		D2995	BEARPAW
			2	D2996	BEARPAW
4	4	4		D2182B050	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274	RADIUS BLOCK
4	4	4		D2438	CLAMP
			4	D2519	CLAMP
8	8	8	8	D2529	WASHER
		8	8	AN4-13A	BOLT
8	8			AN4-15A	BOLT
8	8	8	8	AN960JD416	WASHER
8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
			4	QS100M24S	CLAMP

REFERENCE ONLY

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Revision: **A**

Date: 01.02.21

Change Record

PAGE 1 OF 1

Part Number: D500-572-011

Description: BEARPAW INSTALLATION (500/520)[illegible]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation		Disposition			

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
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